

Work Order ID 160788

Thursday, May 04, 2017 9:58:35 AM

160788

Page 1

Item ID: D212-1024-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bell Medium Main Rotor Tie Down
 Start Date: 5/5/2017 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 5/17/2017 Req'd Qty: 3.00 ***3*** Customer:
 Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: PA **DAS 21 9-89** Date: 2017/05/04 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D212-1024	REV A	JUN 01 2017 DAS 6 9-89							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.06							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D212-1024-011	CHG001							
110	Pick Kit	0.00							
110	Packaging								
Packaging	Memo	0.06							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 27 9-89

JUN 01 2017

3 CNB

JUN 05 2017

DAS 27 9-89

JUN 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging								
Packaging	Memo	0.09							
Packaging	Identify and pack for shipping as per PPP D212-1024-011 Location : fg 018								
280		0.00							
280	QC21- Final Inspection - Work Order Release								
QC	Memo	0.30							
Quality Control									

3X **DAS 27 9-89**
JUN 06 2017
17/6/6
JUN 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Picklist Print

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Work Order ID: 160788

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Parent Item: D212-1024-011

D212-1024-011

Parent Item Name: Bell Medium Main Rotor Tie Down

Start Date: 5/5/2017

Required Date: 5/17/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 16.06.06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5312-1 *D5312-1* Tie Down Bracket		Manufactured	No			110	Each	17.0000	1	3			
									**	CWB		JUN 05 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST163				17					
				147963				14					
				150368				3		3			
D5344-041 *D5344-041* Bell Medium Main Rotor Tie Down - Tie Down Assembly		Manufactured	No			110	Each	3.0000	1	3			
									**	CWB		JUN 05 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST442				3					
				150459				3		3			
MS24693-274B *MS24693-274R* SCREW		Purchased	No			110	Each	32.0000	3	9			
									**	CWB		JUN 05 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST287				32					
				m135352				32		9			
MS24693-275B *MS24693-275R* SCREW		Purchased	No			110	Each	22.0000	3	9			
									**	CWB		JUN 05 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST287				22					
				m135603				22		9			

DQA: _____ Date: _____



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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

5. PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D212-1024-011	Main Rotor Tie Down
	X	D212-1024-013	Fixed Provisions
1	1	D5312-1	Tie Down Bracket
1		D5344-041	Tie Down Assembly
1		*D5339-1	*Carabiner Clip
1		*D5340-1	*Tennis Ball
1		*D5341-1	*Nylon Rope
1		*D5342-1	*Rope Clamp
1		*D5343-1	*Long Hook
3	3	MS24693-274B	Screw
3	3	MS24693-275B	Screw

*Included in D5344-041

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Approvals: **Process Plan:** PA **Date:** 2017/05/04 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

[illegible]



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH16-24

Issue No.: 1

Approval Date: May 31, 2016

Issue Date: May 31, 2016

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

Bell 205A, 205A-1, 205B, 212

Canadian Type Certificate or Equivalent:

H-104 (Bell 205B)

H-86 (Bell 212)

H1SW (Bell 205A, 205A-1)

Description of Type Design Change:

Main Rotor Tie Down

**Installation/Operating Data,
Required Equipment and Limitations:**

Installation of the Main Rotor Tie Down must be in accordance with Transport Canada Civil Aviation (TCCA) approved Dart Aerospace Limited (Ltd) Installation Instructions, IIN-D212-1024 Revision A, dated October 13th 2015 or later TCCA approved revision.

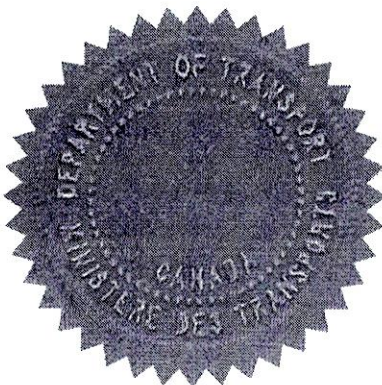
Maintenance of the Main Rotor Tie Down must be in accordance with TCCA accepted Instructions for Continued Airworthiness, ICA-D212-1024 Revision 0, dated October 23rd 2015 or later TCCA accepted revision.

Definition of the Type Design Change: TCCA approved Master Document List, MDL-D212-1024 Revision A, dated May 18th 2016 or later TCCA approved revision.

Basis of Certification for Affected Areas: 14 CFR Part 29 dated February 1st, 1965 including amendments 29-1 and 29-2.

— End —

Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.



Loy Y. Liew
For Minister of Transport